

Work Order ID 83175

April-13-12 10:42:42 AM

83175

Page 1

Item ID: D3940-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Floor Protector (407)

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/13* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------------|--------------|
| <i>D3940-1</i> | <i>Rev A</i> |

12-04-13

100

HandThermo

Hand Finishing Thermoforming

Memo

1-Cut Sheet to required Blank size

0.00

x2

Dh

12/04/26

105

0.00

105

HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 POLYCARBONATE

0.00

x2

Dh

12/04/26

Temp: *240°i*

Time IN: *7:00 am* *12/04/25*

Time OUT: *6:00 am* *12/04/26*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 83175

April-13-12 10:42:42 AM

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Page 2

Item ID: D3940-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Protector (407)

Stop

NS2

Start Date: 13/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA042 using tool DT9502
Dwg Rev: A
Folio Rev: B

x2

dh

12/04/12

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

Visually inspect part for proper formation and texture

x2

dh

12/04/12

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

(2)

B

12/04/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

83175

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 13/04/2012 **Start Qty:** 2.00

~

Cust Item ID:

Required Date: 27/04/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 83175***83175***

Page 4

April-13-12 10:42:42 AM

Item ID: D3940-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Protector (407)

Stop

NS2

Start Date: 13/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

2

12/5/28

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/05/02

MLJ 12/05/02

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-13-12 10:42:46 AM

Page 1

Work Order ID: 83175

83175

Parent Item: D3940-1

D3940-1

Parent Item Name: Floor Protector (407)

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 09/02/06 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.118-90318-08 | | Purchased | No | | | 100 | sf | 1,383.746 | 9.03 | 18.06 | | | |

MI FXS 118-90318-08

Lexan Sheet

**

Location

Loc Qty

Loc Code

therm

1383.746941

113127

1383.74694

18.06 sq ft

DL
12/04/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|------------------------------|--------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 83175 |
| Description: Floor Protector | | Part Number: | D3940-1 |
| Inspection Dwg: D3940 | Rev: A | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than <u>N/A</u> | | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

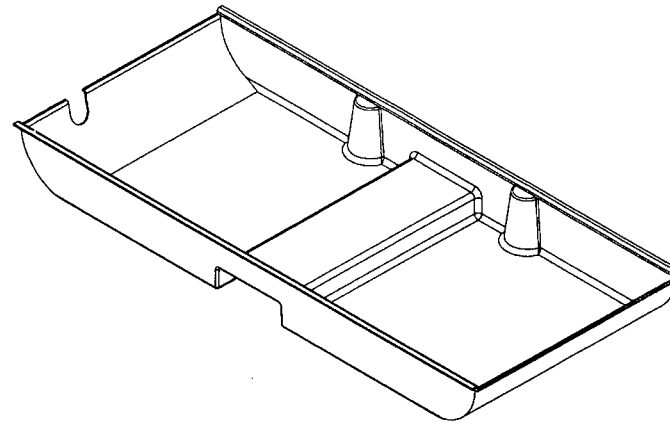
| | |
|------------------------|-----------------------|
| Measured by: <u>Sh</u> | Date: <u>12/04/26</u> |
|------------------------|-----------------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 45.8 | REF | 45.875 | ✓ | | TH-05 | |
| 20.8 | REF | 20.825 | ✓ | | TH-05 | |
| 0.50 | Min | .568 | ✓ | | TH-01 | |
| 0.62 | Min | .653 | ✓ | | TH-01 | |
| 0.38 | Min | .425 | ✓ | | TH-01 | |
| 0.080 | Min | .091 | ✓ | | TH-01 | |
| 0.050 | Min | .071 | ✓ | | TH-01 | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | |
|--------------------------------|-----------------------|
| Measured by: <u>Sh</u> | Date: <u>12/05/01</u> |
| Audited by: <u>Sh</u> | Date: <u>12/05/01</u> |
| Prototype Approval: <u>N/A</u> | Date: <u>N/A</u> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-----------|
| A | 09.09.17 | New Issue | KJ | <u>Sh</u> |



D3940-1 FLOOR PROTECTOR (407)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 83175 *MLJ*

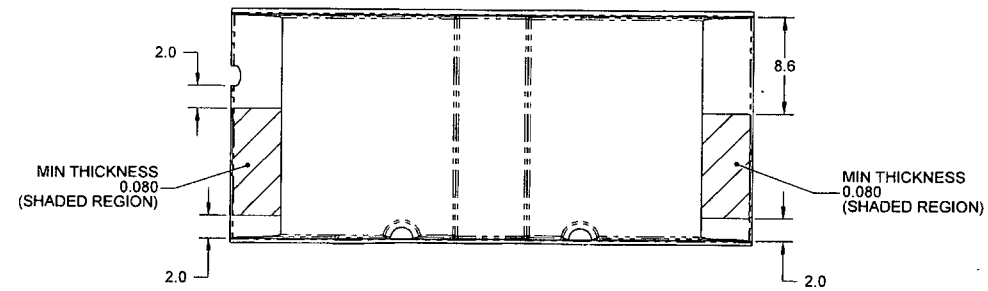
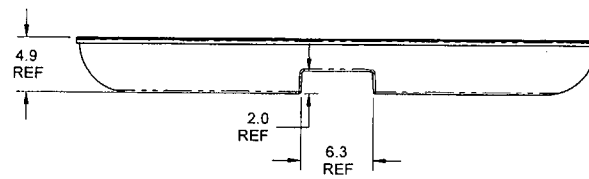
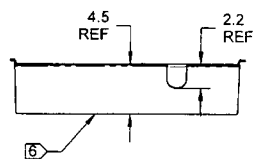
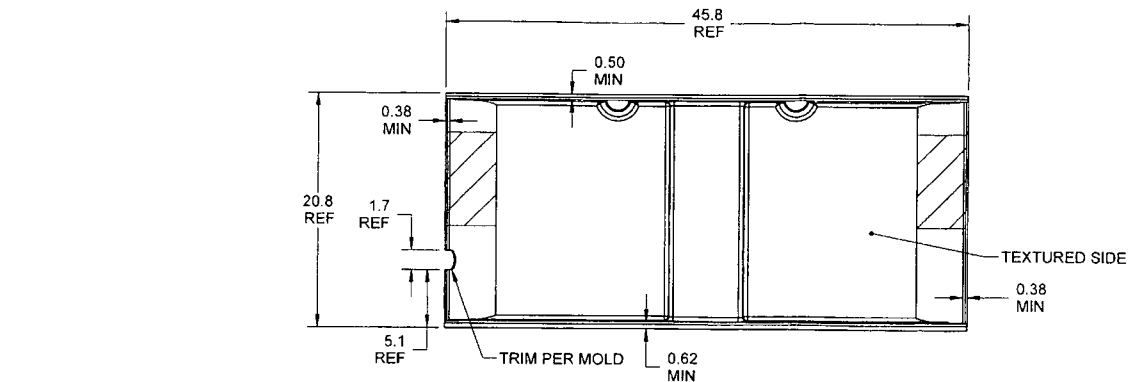
12/04/13

RELEASED
01/04/13

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3940-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9502 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

| | | | |
|------------|-----------|---|--------------|
| A | NEW ISSUE | PH | 09.04.01 |
| REV. | | BY | DATE |
| DESIGN | <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>PH</i> | | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>PH</i> | D3940 | SHEET 1 OF 2 |
| APPROVED | <i>PH</i> | TITLE | SCALE |
| DE APPR. | <i>PH</i> | FLOOR PROTECTOR (407) | NTS |
| DATE | 09.04.01 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



D3940-1 FLOOR PROTECTOR (407)

RELEASED
07/06/08 NW

| | | | |
|---|----------|------------------------------|--------------|
| DESIGN | BH | DART AEROSPACE LTD | |
| DRAWN | BH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3940 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FLOOR PROTECTOR (407) | |
| DATE | 09.04.01 | NTS | |
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